

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34462  
Estimate Number : 12364  
P.O. Number :  
This Issue : 9/7/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : LARGE FAB ASSY  
Previous Run : 30764  
Written By :  
Checked & Approved By :  
Comment : Est Rev A New Issue 06-04-11 JLM

Drawing Name : TAIL LIGHT FAIRING  
Part Number : D3484041  
Drawing Number : D3484 REV D  
Project Number : N/A  
Drawing Revision : D  
Material :  
Due Date : 9/30/2007

Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34841 BASE, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

BASE, LH

Batch: ~~B 34456-1~~ → 7x

08/01/18  
07-12-06 (2)

2.0 D34843 FACE, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

FACE, LH

Batch: ~~B 34458~~ → 7

08/01/18  
07-12-06 (2)

3.0 D34845 CONE, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

CONE, LH

Batch: ~~B 34460-1~~ → 7x

08/01/18  
07-12-06 (2)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig

A/R AL ROD Batch: ~~XXXXXXXXXX~~ 1104855

2-Buff & Smooth Welds to mating surfaces

08/01/23  
07-12-07 (2)  
07-12-07 (2)





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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34462

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

21 08-01-22 (7)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-24 (7)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

48

08-01-24

(X7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-24 (7)

9.0

MS20426AD33

CR122-3-02.5

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

Batch: 17106878

FF 08-01-25 (4)

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

ANCHOR NUT

Batch: 17103693

FF 08-01-25 (4)

11.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

FF 08-01-25 (4)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-25 (4)





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34462

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

POWDER COATING

POWDER COATING



M106379



(IX)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1

08/01/25

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-25

(XI)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-141 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

P-1/25 (1)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/01/25

→ 15 B

Inspect level 5  
Check P/N to Drawing

08/01/25 (16)

Permanent Change  
125

PTC



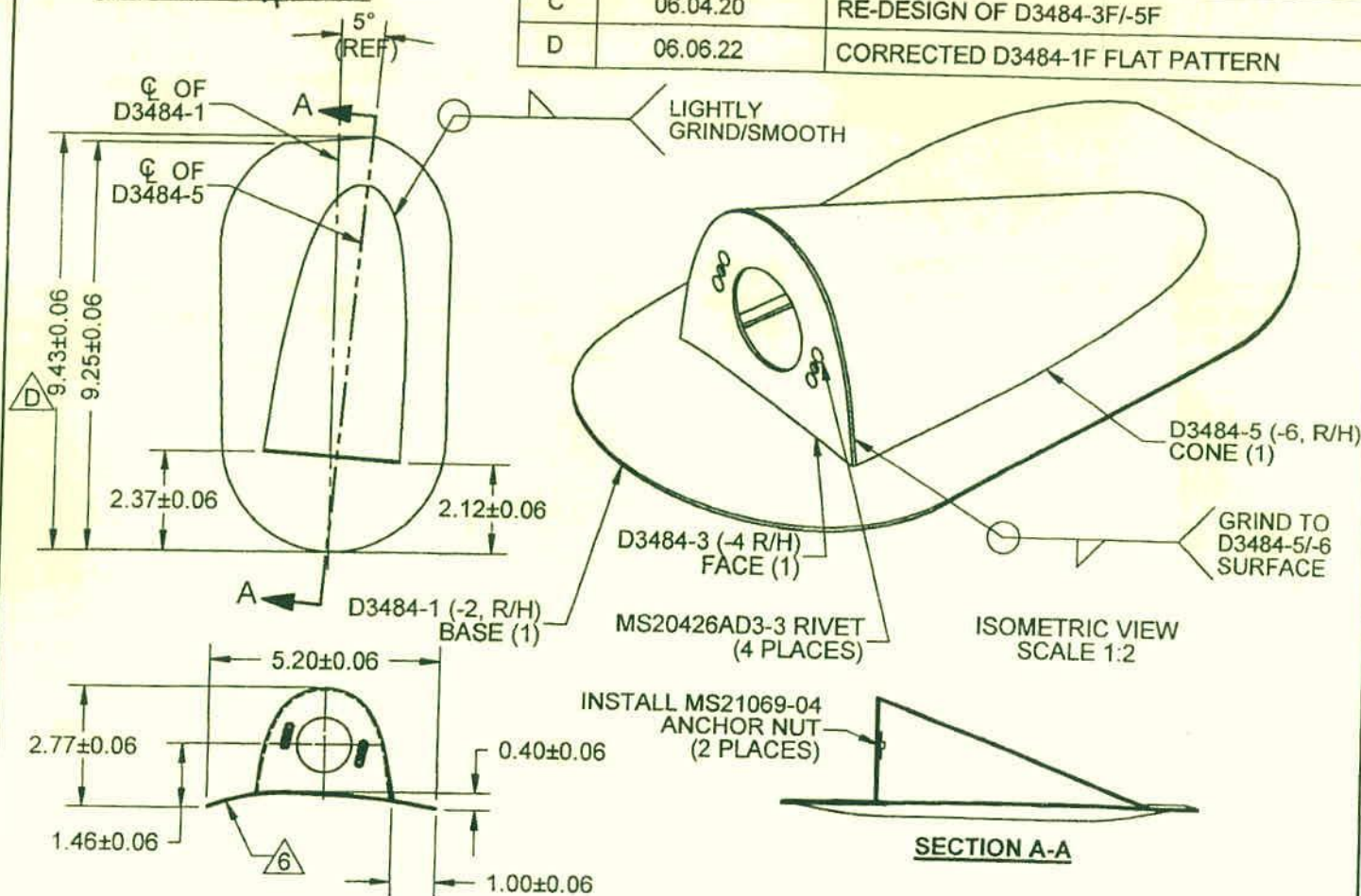


**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE	06.06.22	TITLE TAIL LIGHT FAIRING	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

RELEASED

06.08.17 #

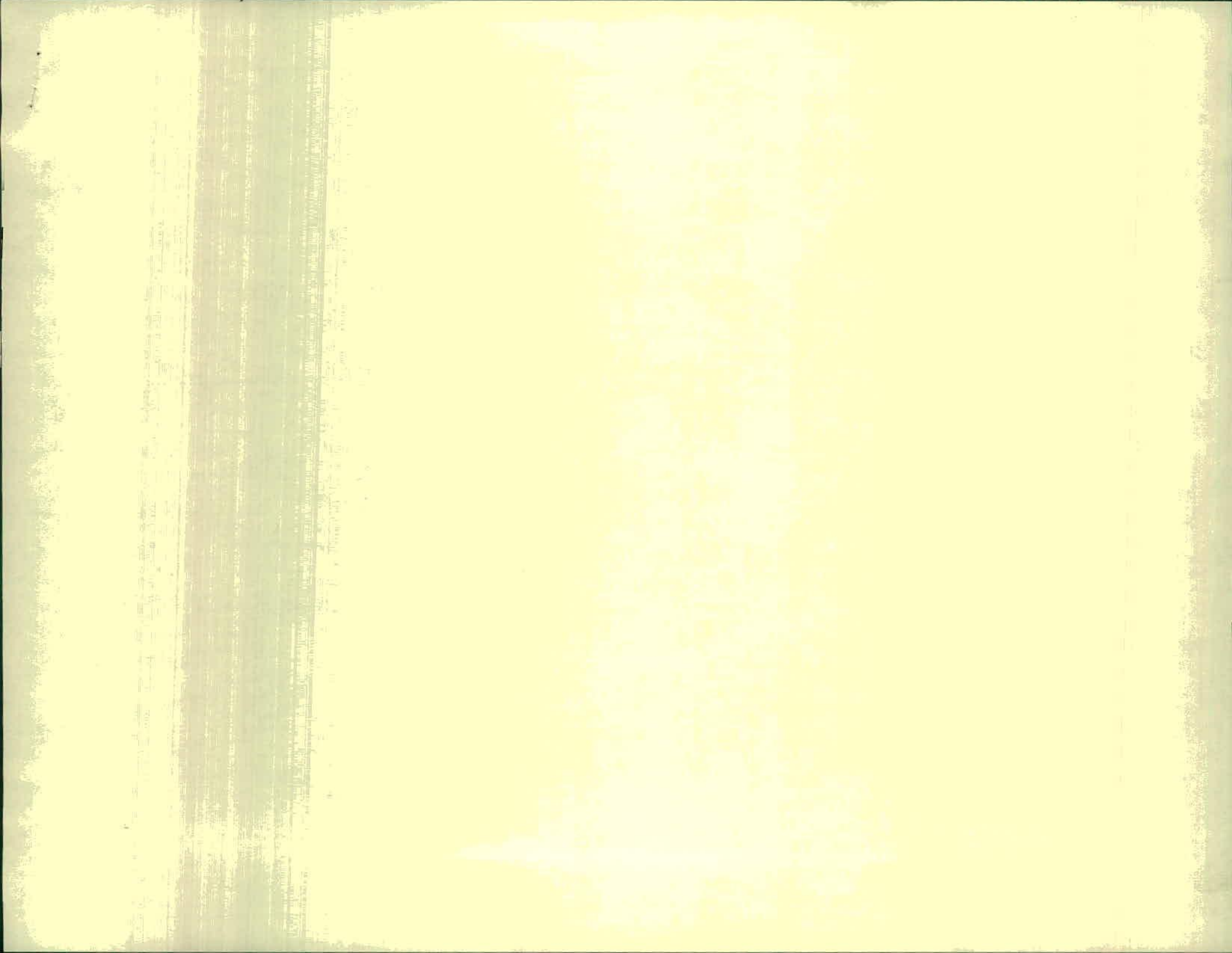
**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD.,  
P/N D412-750-141/-142 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE  
PDA06-13"

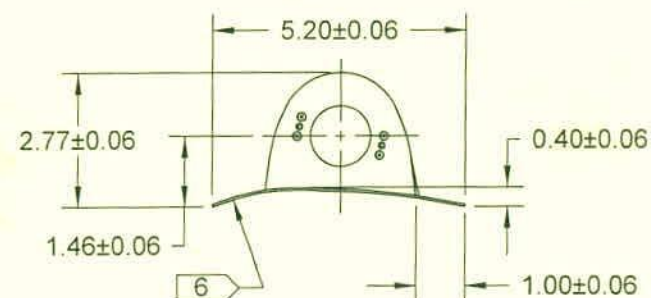
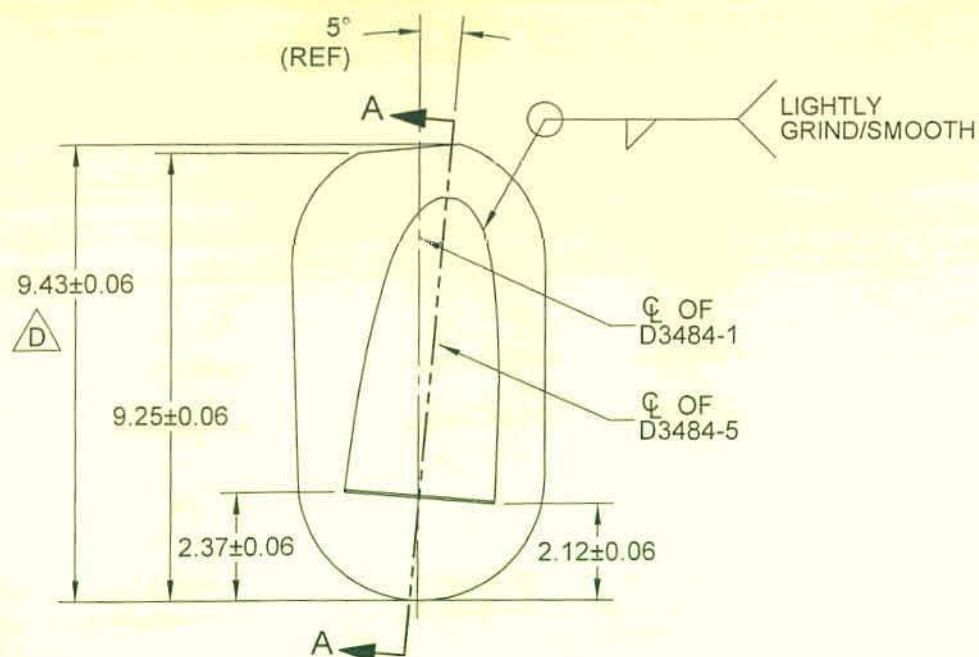
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

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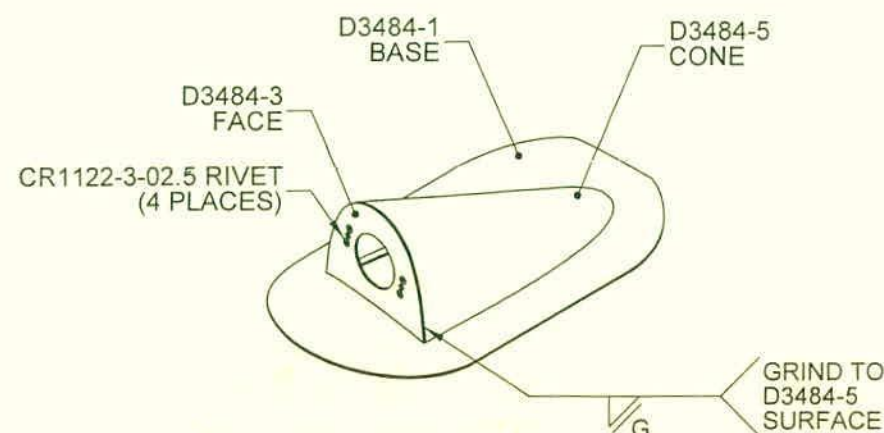






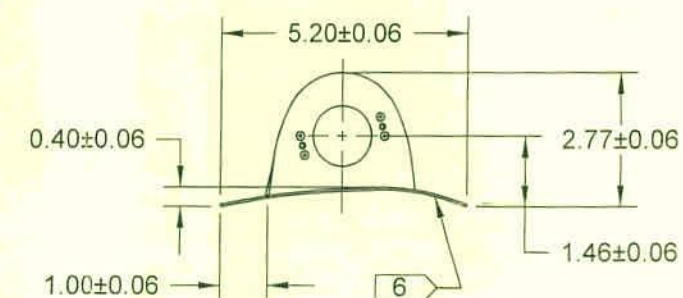
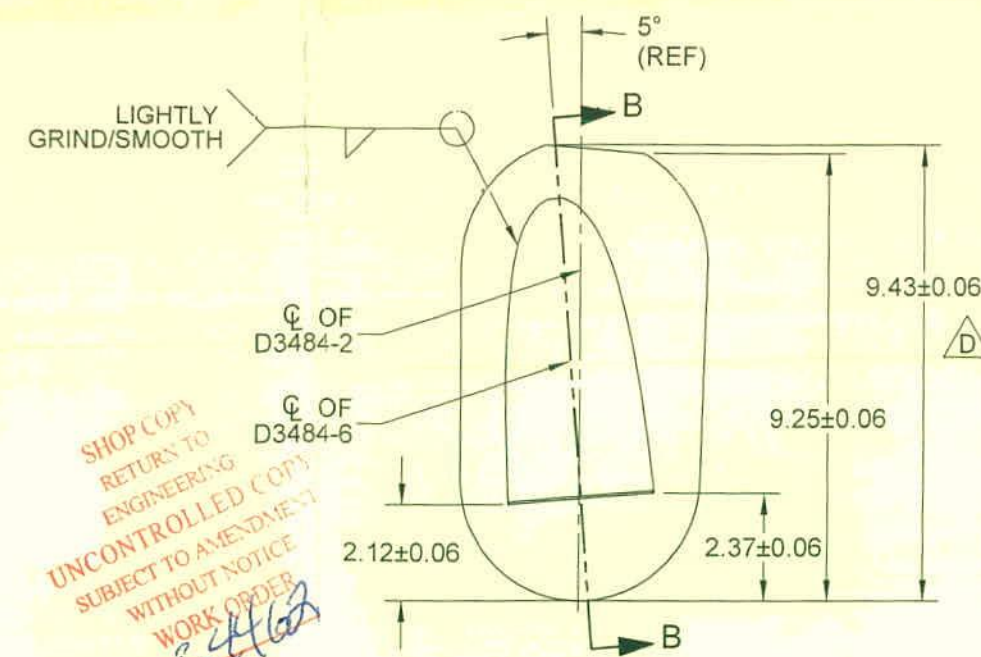
SECTION A-A

D3484-041 TAIL LIGHT FAIRING



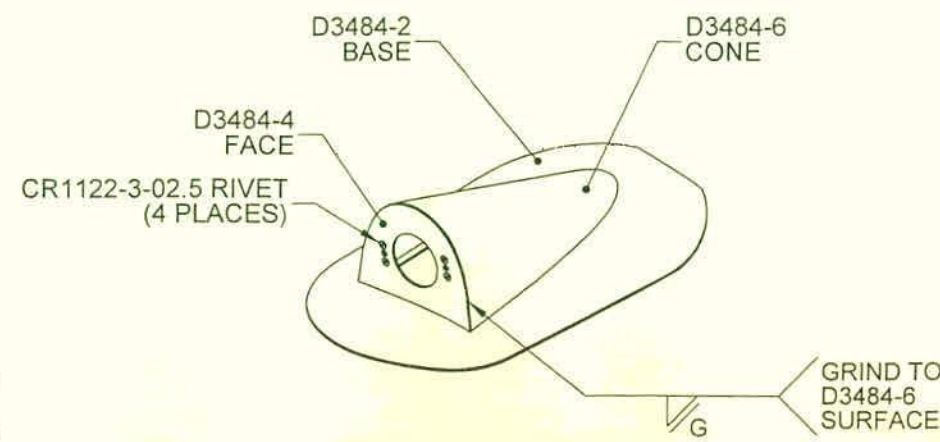
D3484-041 ISOMETRIC VIEW

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



SECTION B-B

D3484-042 TAIL LIGHT FAIRING



D3484-042 ISOMETRIC VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 3462

RELEASED  
08.01.03

E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.03		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3484  
REV. E  
SHEET 1 OF 4  
TITLE TAIL LIGHT FAIRING  
SCALE 1:4

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